

Work Order ID: 85669

June-13-12 1:51:42 PM

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Item ID: D412-742-013

Revision ID:

Item Name: Float Skidtube Installation

Start Date: 6/13/12 Start Qty: 1.00

Required Date: 6/14/12 Req'd Qty: 1.00

Reference: RMA RA111377

Cust Item ID:

Customer: CU-DAR001

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-742	E

100

0.00

100

QC

Quality Control

Memo

INSPECT RA111377
1 X D412-742-013 B81083

0.00

5/12/13

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT/CANADA K6A 1K7				TC APPROVAL # 0482 TEL: 1-613-632-6200	
PN	D412-742-013	CHG	CHG007		
DESC	Float Skidtube	SIC	SR01583SE		
LOT	B81083	SIC	SH05-37		
MODEL	205/210/212/412/AB412	SIC			
PATENTS US 5,735,484 CA 2,222,185 EUROPEAN NO. 0,082,865				MADE IN CANADA 027232	

110

0.00

110

HandFinish

Hand Finishing

Memo

REMOVE FWD AND AFT WEARPLATES
HAVE QC TEST FIT SADDLES

0.00

RE-INSTALL ORIGINAL FWD AND AFT WEARPLATES AFTER TEST FIT
OF SADDLES

REMOVE AFT CAP AND FWD CAP-SCRAP/DESTROY

REPLACE

NEW AFT CAP 1 X D2646 B 81974
NEW FWD CAP 1 X D3401-041 B 83432
TOUCH UP ANY AREAS A/R

5/12/15

Bull marks / scratches out per test allow 4 thickness.

12-6-19

1x f M 1106/19
tribeam
only
D412-742-013

PTO 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/06/15	110	Strip & Touch-up Alodine Fwd Extrusion	M	12/06/15	XL	W 12-6-21	M 12-06-21
12/06/15	110	Powder Coat + QC3 PART Finish START: 10:40= TEMP: 325°F Finish: 11:10 M120222 / QC3 inspection PART Finish	M-L BL	12/06/14 12-6-19	1X 1X	M-L 12-06-21	M-L 12-06-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dan Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/06/15	110	Assemble with: D2646 / B81974 (end-cap) D3591-1 / B83237 (x2) D3401-041 / B83432 (Tow-cap)	MM	12/06/15	(x1) (x1)			
12/06/15	110	AHS4-1032-225 / M121269 (inserts) AN3C4A / M121205 (bolts) NAS1149C0332R / M122063 (washers) D3672-1 / B80369 (Phenolic washers)	MM	12/06/15	(x10) (x4) (x4) (x4)			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85669

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Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Float Skidtube Installation
Start Date: 6/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/14/12 Req'd Qty: 1.00 ***1*** Customer: CU-DAR001
Reference: RMA RA111377

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130									
130									
Packaging	Memo								
Packaging	ENSURE ORIGINAL KIT IS IN BOX								
140									
140									
QC	Memo								
Quality Control									

8/16/19

N/A was shipped out on another w/o. - will be closed and pulled on 0412-742-013 #85243

12.06.20

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Item ID: D412-742-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 6/13/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/14/12 Req'd Qty: 1.00

1

Customer: CU-DAR001

Reference: RMA RA111377

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

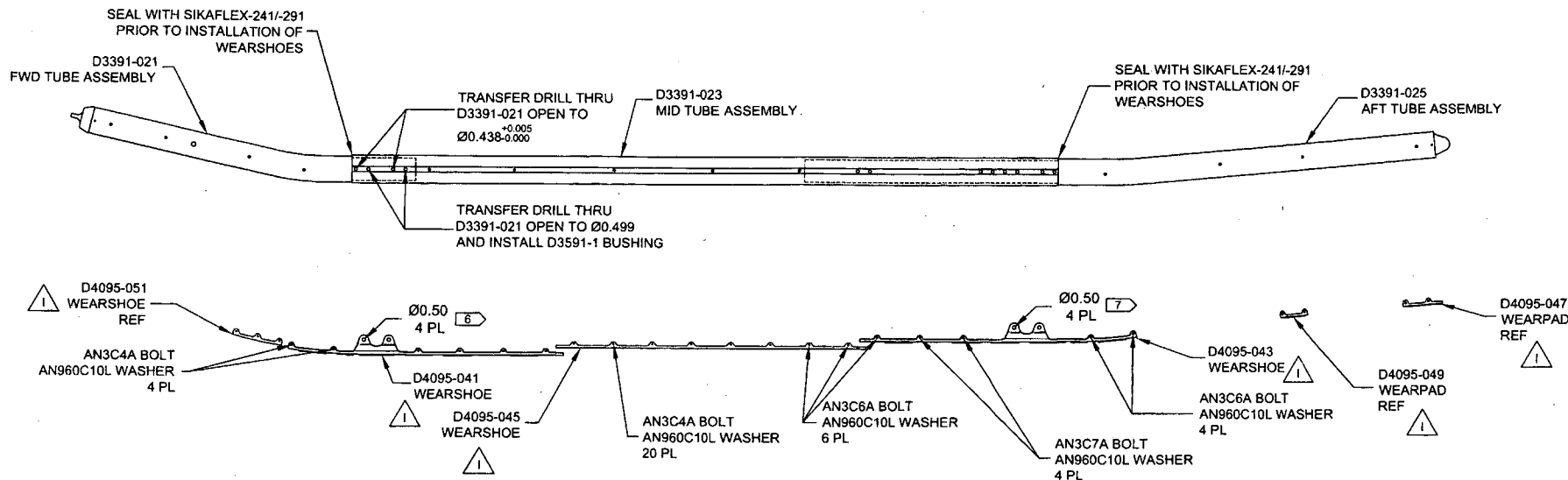
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

see
w/o 8/6/55
MF
12-06-20

MCJ 12/06/12
MF
12-06-29



D3391-043 ASSEMBLY



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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**Instructions for RA 111377 D412-742-013 B83154 CHG
007**

- Box was damaged see pictures
- Kit complete
- Aft cap is scrap **see pic**
- Fwd. cap is scrap **see pic**
 - Aft angle = **6.58***
 - Fwd. angle = **13.0***
 - Remove fwd. and aft wear plates and test fit saddles
- Needs new BATCH #
- Needs new Paper Work & Labels

Time Estimate = 5 HOUR ONLY
Departments Required: 4-FINISHING 1-STORES
Pictures Attached = YES

**Instructions for RA 111377 D412-742-013 B81083
CHG007**

- Box was damaged see pictures
- Kit complete
- Aft cap is scrap **see pic** *D2646*
- Fwd. cap is scrap **see pic** *D344.241*
 - Aft angle = **6.0***
 - Fwd. angle = **12.23***
 - Remove fwd. and aft wear plates and test fit saddles
- Needs new BATCH #
- Needs new Paper Work & Labels

Time Estimate = 5 HOUR ONLY (stores)
Departments Required: 4-FINISHING 1-STORES
Pictures Attached = YES

Work Order ID 86055

86055

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Wednesday, June 20, 2012 10:44:11 AM

Item ID: D412-742-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Float Skidtube

Start Date: 6/20/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/20/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *muc*

Date: *12-06-20*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3391

1

150

0.00

150

QC

Memo

0.00

Quality Control

WORK ORDER WAS CREATED FOR TRI-BEAM TO BE ABLE TO PULL
REWORK ONTO NEW D412-742-013.
K-KIT WAS ALREADY SHIPPED OUT ON ORIGINAL W/O

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

Picklist Print

Wednesday, June 20, 2012 10:44:10 AM

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Work Order ID: 86055

Parent Item: D412-742-043

Start Date: 6/20/2012

Required Date: 6/20/2012

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC
 REV.B DD verified by:EC
 IPP Rev:F 11.11.01 as per DS19517

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-742-013 Float Skidtube Installation		Manufactured	No				Each	0.0000		1			

85669